Att.F-1a

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS	REVIE	W DATE	ESTABLISHMENT NO. AND NAME		Århus		
FOREIGN PLANT REVIEW FORM	2/1	8/2002	34 - Århus Slagterhu	s A/S		COUNTRY Denmark	
NAME OF REVIEWER Dr. Gary D. Bolstad	Drs.	H. Peter	ign Official sen, Palle Andersen, O. Moelle	ceptable/ X Unaccep	ptable		
CODES (Give an appropriate code for each A = Acceptable M = Margin			J below) U = Unacceptable	N =	Not Reviewed	O = Does not app	p ly
1. CONTAMINATION CONTROL		Cross o	contamination prevention	28 M	Formulations		55 O
(a) BASIC ESTABLISHMENT FACILITIES		Equipm	ent Sanitizing	29 A	Packaging mater	i	56 O
Water potability records	01 A	Produc	t handling and storage	30 A	Laboratory confi		57 O
Chlorination procedures	02 O	Produc	t reconditioning	31 A	Label approvals		58 O
Back siphonage prevention	03 A	Produc	t transportation	32 A	Special label cla		⁵⁹ O
Hand washing facilities	°4 U	(d) E	STABLISHMENT SANITATION PROGRA	M	Inspector monito		60 O
Sanitizers	05 A	Effecti	ve maintenance program	33 M	Processing sche	dules	61 O
Establishments separation	06 A	Preope	rational sanitation	34 A	Processing equip	oment	62 O
Pestno evidence	07 A	Operat	ional sanitation	35 M	Processing reco	rds	63 O
Pest control program	08 A	Waste	Waste disposal 36 Empty can			ection	64 O
Pest control monitoring	09 A		2. DISEASE CONTROL		Filling procedure	es	65 O
Temperature control	10 A	Anima	l identification	37 A	Container closure exam		66 O
Lighting	יי	Antem	ortem inspec. procedures	38 A	Interim container handling		67 O
Operations work space	12 A	Antem	ortem dispositions	39 A	Post-processing handling		68 O
Inspector work space	13 A	Huma	ne Slaughter	40 A	Incubation procedures		69 O
Ventilation	14 A	Postm	ortem inspec. procedures	41 M	Process. defect actions plan		70 O
Facilities approval	15 A	Postm	ortem dispositions	42 A	Processing control inspec		71 O
Equipment approval	16 A	Conde	emned product control	43 A	5. COMPLIANCE	/ECON. FRAUD CONTR	OL
(b) CONDITION OF FACILITIES EQUIPMI	ENT	Restricted product control		44 A	Export product identification		72 A
Over-product ceilings	17 A	Returi	ned and rework product	45 A	Inspector verifi	cation	73 A
Over-product equipment	18 A		3. RESIDUE CONTROL		Export certifica	tes	74 A
Product contact equipment	19 A	Resid	ue program compliance	46 A	Single standard	<u> </u>	75 A
Other product areas (inside)	20 A	Samp	ling procedures	47 A	Inspection sup	ervision	76 M
Dry storage areas	21 A		ue reporting procedures	48 A	Control of secu	rity items	77 A
Antemortem facilities	22 A	Appro	oval of chemicals, etc.	49 A	Shipment secu	rity	78 A
Welfare facilities	23 A	Stora	ge and use of chemicals	50 A	Species verific	ation	79 O
Outside premises	24 A		4. PROCESSED PRODUCT CONTROL	l	"Equal to" stat	us	80 U
(c) PRODUCT PROTECTION & HANDL			oning trim	51 O	Imports		81 O
Personal dress and habits	25 A	Popo	less meat reinspection	52 O			82 A
Personal hygiene practices	26 U		dients identification	53 O			83 U
Sanitary dressing procedures	27 U		rol of restricted ingredients	54 C	<u> </u>		+
- •	1 0		-	ı ~			1

FOREIGN PLANT REVIEW FORM (reverse)	2/18/2002	ESTABLISHMENT NO. AND NAME 34 - Århus Slagterhus A/	CITY Århus
	2/18/2002	34 - Allius Siagietiius A	 COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	Drs. H. Peter	eign official esen, Palle Andersen, O. Moeller	cceptable/ X Unacceptable

- 04 Neither of the two leggers on the slaughter line had a hand soap dispenser. The DVFA officials ordered prompt correction.
- 11 Lighting was inadequate at all inspection stations. The European Commission regulations require 540 Lux, or 49 foot-candles (fc) of light. The Auditor measured 35 fc at the head lymph nodes, 30 fc on beef necks, 20 fc on the viscera tray, and only 10 fc in abdominal cavities. The DVFA officials ordered prompt correction.
- 26 (A) The establishment worker examining beef quarters for visible contamination prior to shipping did not wash his hands after handling contaminated trimmings, thus further contaminating product. Corrective actions were attempted twice by the establishment management, and were ineffective both times. (B) The establishment worker responsible for trimming visible contamination on the slaughter line did not wash his hands after handling contaminated trimmings, thus further contaminating product. The DVFA officials ordered immediate corrective action.
- 27 Several butchers on the slaughter line were observed to fail to sterilize their knives after making opening skin cuts before continuing their skinning operations. The DVFA officials ordered corrective actions, but they were not effective immediately.
- 27/83 The written HACCP plan called for the designated carcass trimmer, whose position on the slaughter line was immediately after the carcass inspector, to document the incidence of fecal contamination. This was not being done. The establishment was relying on the DVFA final carcass inspector to document electronically the fecal contamination he observed, and when the more than four out of ten consecutive carcasses were noted with fecal contamination, an alarm on the foreman's telephone would be activated. The last documented incidence of the action level of more than 4 out of 10 carcasses with visible fecal contamination was October 13, 1999. the Auditor observed three out of ten quarters ready for shipping that had visible fecal contamination. These quarters had passed not only inspection on the slaughter line, but also pre-shipping inspection. Furthermore, visible fecal contamination and/or pieces of hide were observed on approximately 30% of beef halves on the first rail examined in the coolers, and also on two tails that were ready for packing. The DVFA officials ordered re-inspection of all the carcasses and the tails.
- 28 Large plastic containers for edible product were routinely placed directly on the floor. The DVFA officials agreed to require corrective actions. Also, beef tails routinely contacted equipment at the bung-dropping station. No corrective actions were taken.
- 33 Several cracked or torn stainless steel combo bins were observed; the DVFA officials ordered repair or replacement.
- 35 (A) Several containers for edible product ready for use had not been adequately cleaned. The DVFA officials ordered them to be re-cleaned. (B) A large combo bin of edible product (trimmed fat) had been left uncovered and had been temporarily placed outside the establishment. The Veterinarian-In-Charge condemned the product.
- 41 The head inspector was routinely making only one rapid incision into each of some beef head lymph nodes and was not adequately observing the cut surfaces. The DVFA officials corrected this immediately.
- 76 The Veterinarian-In-Charge demonstrated a plan for his staff to conduct weekly verification of ten establishment activities. For all but one of the categories, verifications had not been performed during the majority of the eight weeks that had elapsed since the beginning of the year. During three of the eight weeks, none of these activities, including controls for fecal contamination and operational sanitation, had been performed.
- 83a The establishment management had not developed a statistical process control procedure for the evaluation of the results for *E. coli* testing; they were mistakenly using the method re-served for excision sampling. This was discussed in detail both during the establishment audit and at the country exit meeting. The DVFA officials notified the inspection personnel in all establishments certified as eligible for export to the U.S. within 48 hours of this finding in Est. 34.
- 83b Only one HACCP plan had been developed, which covered all products, some of which had different critical limits for temperature (for different customers) at shipping. DVFA agreed to ensure that separate HACCP plans would be developed for each product.
- 80 See above. The DVFA officials agreed with the FSIS Auditor that the establishment failed to meet the USDA requirements and voluntarily withdrew it from the list of establishments certified as eligible to export meat products to the United States, effective as of the start of operations on the day of the audit.

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS	REVIE	W DATE	ESTABLISHMENT NO. AND NAME			CITY Saeby	
FOREIGN PLANT REVIEW FORM	2/1	1/2002	/2002 71 - Danish Crown Saeby			COUNTRY Denmark	
NAME OF REVIEWER Dr. Gary D. Bolstad	Drs.	J.M.Ebb	IGN OFFICIAL besen, I. Lahmann, N.R.Anderse	EVALUATION Acceptable Re-	eptable/ Unacce	ptable	
CODES (Give an appropriate code for each A = Acceptable			l below) U = Unacceptable	N =	= Not Reviewed	O = Does not app	pły
1. CONTAMINATION CONTROL		Cross o	ontamination prevention	28 M	Formulations		55 A
(a) BASIC ESTABLISHMENT FACILITIES		Equipm	ent Sanitizing	29 A	Packaging materi	als	56 A
Water potability records	01 A	Produc	t handling and storage	30 A	Laboratory confir	mation	57 A
Chlorination procedures	02 O	Produc	t reconditioning	31 A	Label approvals		58 A
Back siphonage prevention	03 A	Produc	t transportation	32 A	Special label clair	ns	59 O
Hand washing facilities	04 A	(d) E	STABLISHMENT SANITATION PROGRAI	W	Inspector monito	ring	60 A
Sanitizers Orange	05 A	Effecti	ve maintenance program	33 M	Processing sched	lules	61 A
Establishments separation	06 A	Preope	rational sanitation	34 M	Processing equip	ment	62 A
Pestno evidence	07 A	Operat	ional sanitation	35 A	Processing record	ds	63 A
Pest control program	08 A	Waste	disposal	36 A	Empty can inspe	ction	64 O
Pest control monitoring	09 A		2. DISEASE CONTROL		Filling procedures	S	65 O
Temperature control	10 A	Anima	identification	37 A	Container closure exam		66 O
Lighting	11 A	Antem	ortem inspec. procedures	38 A	Interim container handling		67 O
Operations work space	12 A	Antem	ortem dispositions	39 A	Post-processing handling		68 A
Inspector work space	13 A	Humar	ne Slaughter	40 A	Incubation procedures		69 O
Ventilation	14 A	Postm	ortem inspec. procedures	41 A	Process. defect actions plant		70 A
Facilities approval	15 A	Postm	ortem dispositions	42 A	Processing contr	ol inspection	71 A
Equipment approval	16 A	Conde	mned product control	43 A	5. COMPLIANCE/	CON. FRAUD CONTR	OL
(b) CONDITION OF FACILITIES EQUIPMENT	NT	Restric	ted product control	44 A	Export product is	dentification	72 A
Over-product ceilings	17 A	Return	ed and rework product	45 A	Inspector verific	ation	73 A
Over-product equipment	18 A		3. RESIDUE CONTROL		Export certificat	es	74 A
Product contact equipment	19 M	Residu	ie program compliance	46 A	Single standard		75 A
Other product areas (inside)	20 A	Sampl	ing procedures	47 A	Inspection super	rvision	76 A
Dry storage areas	21 A	Residu	ie reporting procedures	48 A	Control of secur	ity items	77 A
Antemortem facilities	22 A	Appro	val of chemicals, etc.	49 A	Shipment securi	ty	78 A
Welfare facilities	23 A	Storag	ge and use of chemicals	50 A	Species verifica	tion	79 A
Outside premises	24 A		4. PROCESSED PRODUCT CONTROL	<u> </u>	"Equal to" statu	ıs	80 A
(c) PRODUCT PROTECTION & HANDLIN	IG	Pre-bo	oning trim	51 A	Imports		81 A
Personal dress and habits	25 A	Bonel	ess meat reinspection	52 A	SSOPs		82 A
Personal hygiene practices	26 A	Ingred	lients identification	53 A	HACCP/PR		83 M
Sanitary dressing procedures	27 A	Contr	ol of restricted ingredients	54 O			

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FOREIGN PLANT REVIEW FORM (reverse)	2/11/2002	ESTABLISHMENT NO. AND NAME 71 - Danish Crown Saeby	Saeby COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FORE Drs. J.M.Ebb	EIGN OFFICIAL Desen, I. Lahmann, N.R.Andersen	ceptable/ Unacceptable

- 28 There was inadequate separation of containers for inedible product from containers for edible product. Also, floor-cleaning equipment was not routinely kept separate from edible product contact surfaces and aprons. The observed instances were corrected immediately, and the DVFA officials ordered immediate review of the program and implementation of improved controls.
- 33 Maintenance and cleaning of some over-product equipment had been neglected in several areas throughout the establishment. This was a partial repeat finding; similar deficiencies had been observed in other areas during the March-April FSIS audit, but those areas had received the appropriate attention. The management representatives gave assurances they would extend the improved maintenance procedures to the newly-identified problem areas.
- 19/34 A considerable number of product-contact surfaces were not adequately cleaned before the start of operations. Some of these were identified by the establishment representative, but more were identified by DVFA. All were cleaned before operations began.
- 83 Documentation of the Critical Limits for temperatures in the coolers and freezers had improved, but documentation of corrective actions when critical limits were exceeded was still in need of further improvement.

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U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE	REVIE	W DATE	ESTABLISHMENT NO. AND NAME			CITY Hjørring	
FOREIGN PLANT REVIEW FORM	2/1	3/2002	2002 165 - Hjørring Frysehus COUN		COUNTRY Denmark		
NAME OF REVIEWER Dr. Gary D. Bolstad	D	rs. J.M.	IGN OFFICIAL Ebbesen, I. Lahmann, I. Casper			ceptable/ Unacce	ptable
CODES (Give an appropriate code for each A = Acceptable M = Margin			below) U = Unacceptable	N =	Not Reviewed	O = Does not ap	ply
1. CONTAMINATION CONTROL		Cross c	ontamination prevention	28 A	Formulations		55 O
(a) BASIC ESTABLISHMENT FACILITIES		Equipm	ent Sanitizing	29 O	Packaging mater	ials	56 O
Water potability records	01 A	Product	handling and storage	30 A	Laboratory confi	rmation	57 O
Chlorination procedures	02 O	Produc	reconditioning	31 O	Label approvals		58 O
Back siphonage prevention	03 A	Produc	t transportation	32 A	Special label cla	ims	59 O
Hand washing facilities	04 A	(d) E	STABLISHMENT SANITATION PROGRAM	М	Inspector monito	oring	60 O
Sanitizers	05 A	Effectiv	ve maintenance program	33 A	Processing sche	dules	61 O
Establishments separation	06 A	Preope	rational sanitation	34 A	Processing equip	oment	62 O
Pestno evidence	07 A	Operat	ional sanitation	35 A	Processing reco	rds	63 O
Pest control program	08 A	Waste	disposal	36 A	Empty can inspe	ection	64 O
Pest control monitoring	09 A		2. DISEASE CONTROL		Filling procedure	es	65 O
Temperature control	10 A	Animal	identification	37 O	Container closu	re exam	66 O
Lighting	11 A	Antem	ortem inspec. procedures	38 O	Interim containe	er handling	67 O
Operations work space	12 A	Antem	ortem dispositions	39 O	Post-processing	handling	68 O
Inspector work space	13 O	Humar	ne Slaughter	40 O	Incubation proc	edures	69 O
Ventilation	14 A	Postm	ortem inspec. procedures	41 O	Process. defect	actions plant	70 O
Facilities approval	15 A	Postm	ortem dispositions	42 O	Processing cont	trol inspection	71 O
Equipment approval	16 A	Conde	mned product control	43 A	5. COMPLIANCE	/ECON. FRAUD CONTR	:OL
(b) CONDITION OF FACILITIES EQUIPME	NT	Restric	ted product control	44 O	Export product	identification	72 A
Over-product ceilings	17 A	Return	ed and rework product	45 O	Inspector verific	cation	73 A
Over-product equipment	18 A		3. RESIDUE CONTROL		Export certifica	tes	74 A
Product contact equipment	19 O	Residu	e program compliance	46 O	Single standard		75 A
Other product areas (inside)	20 O	+	ing procedures	47 O	Inspection supe	ervision	76 A
Dry storage areas	21 A	Residu	ue reporting procedures	48 O	Control of secu	ırity items	77 A
Antemortem facilities	22 O	Appro	val of chemicals, etc.	49 A	Shipment secu	rity	78 A
Welfare facilities	23 A		ge and use of chemicals	50 A	Species verifica	ation	79 O
Outside premises	24 A		4. PROCESSED PRODUCT CONTROL	<u>, l </u>	"Equal to" stat	us	80 A
(c) PRODUCT PROTECTION & HANDLII		Pre-bo	oning trim	51 O	Imports		81 A
Personal dress and habits	25 A	Bonel	ess meat reinspection	52 O	SSOPs		82 A
Personal hygiene practices	26 A		lients identification	53 O			83 O
Sanitary dressing procedures	27 O	Contr	ol of restricted ingredients	54 O			+

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FOREIGN PLANT REVIEW FORM (reverse)	2/13/2002	ESTABLISHMENT NO. AND NAME 165 - Hjørring Fryschus	 CITY Hjørring
	2/13/2002	105 - Hjørring Pryschus	COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FORE Drs. J.M.	IGN OFFICIAL Ebbesen, I. Lahmann, I. Casper	ceptable/ Unacceptable

COMMENTS:

No comments.

F-4a

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE	REVIE	W DATE	ESTABLISHMENT NO. AND NAME	Ē		CITY Nykoebing	
FOREIGN PLANT REVIEW FORM	2/8	3/2002	/2002 172 - Danfjoerd Frost		t	COUNTRY Denmark	
NAME OF REVIEWER Dr. Gary D. Bolstad			IGN OFFICIAL esen, A.G. Hernann, C.C. Tho	rsen	EVALUATION Acceptable Re-re	ptable/ Unacce	ptable
CODES (Give an appropriate code for each A = Acceptable M = Margin			below) U = Unacceptable	N =	Not Reviewed	O = Does not ap	ply
1. CONTAMINATION CONTROL		Cross c	ontamination prevention	28 O	Formulations		55 O
(a) BASIC ESTABLISHMENT FACILITIES		Equipm	ent Sanitizing	29 O	Packaging materia	ıls	56 O
Water potability records	01 M	Produc	handling and storage	30 A	Laboratory confirm	nation	57 O
Chlorination procedures	02 O	Produc	t reconditioning	31 O	Label approvals		58 O
Back siphonage prevention	03 O	Produc	t transportation	32 A	Special label claim	ns	59 O
Hand washing facilities	04 A	(d) E	STABLISHMENT SANITATION PROGRAI	M	Inspector monitor	ing	60 O
Sanitizers	05 O	Effectiv	ve maintenance program	33 A	Processing schedu	ules	61 O
Establishments separation	06 A	Preope	rational sanitation	34 A	Processing equipm	nent	62 O
Pestno evidence	07 A	Operat	ional sanitation	35 A	Processing record	s	63 O
Pest control program	08 A	Waste	disposal	Empty can inspec	tion	64 O	
Pest control monitoring	09 A		2. DISEASE CONTROL		Filling procedures		65 O
Temperature control	10 A	Animal	identification	37 O	Container closure	exam	66 O
Lighting	11 A	Antem	ortem inspec. procedures	38 O	Interim container	handling	67 O
Operations work space	12 A	Antem	Antemortem dispositions		Post-processing handling		68 O
Inspector work space	13 O	Humar	e Slaughter	40 O	Incubation proced	dures	69 O
Ventilation	14 O	Postm	ortem inspec. procedures	41 O	Process. defect a	ctions plant	70 O
Facilities approval	15 A	Postm	ortem dispositions	42 O	Processing contro	ol inspection	71 O
Equipment approval	16 A	Conde	mned product control	43 O	5. COMPLIANCE/EG	CON. FRAUD CONTR	OL
(b) CONDITION OF FACILITIES EQUIPME	NT	Restric	ted product control	44 O	Export product id	lentification	72 A
Over-product ceilings	17 A	Return	ed and rework product	45 O	Inspector verifica	tion	73 A
Over-product equipment	18 A	1	3. RESIDUE CONTROL		Export certificate	es ·	74 A
Product contact equipment	19 O	Residu	e program compliance	46 O	Single standard	<u> </u>	75 A
Other product areas (inside)	20 A	Sampl	ing procedures	47 O	Inspection superv	vision	76 A
Dry storage areas	21 A	Residu	ue reporting procedures	48 O	Control of securi	ty items	77 A
Antemortem facilities	22 O	Appro	val of chemicals, etc.	49 A	Shipment securit	:y	78 A
Welfare facilities	23 A	Storag	ge and use of chemicals	50 A	Species verificat	ion	79 A
Outside premises	24 A		4. PROCESSED PRODUCT CONTROL		"Equal to" status	<u> </u>	80 A
(c) PRODUCT PROTECTION & HANDLI		Pre-bo	oning trim	51 O	Imports		81 A
Personal dress and habits	25 A	Bonel	ess meat reinspection	52 O	L		82 A
Personal hygiene practices	26 A	Ingred	lients identification	53 O			83 O
Sanitary dressing procedures	27 O	Contr	ol of restricted ingredients	54 O			1

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FOREIGN PLANT REVIEW FORM (reverse)	REVIEW DATE	ESTABLISHMENT NO. AND NAME		CITY
	2/8/2002	172 - Danfjoerd Fros	•	Nykoebing
	2.0.2002	172 - Dainjocid 1103	i.	COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FORE Drs. J.M. Ebb	ign official pesen, A.G. Hernann, C.C. Thorsen		ceptable/ review Unacceptable

01 In April 2001, a high total plate count (TPC) was reported in a routine water sample (440 reported; 200 acceptable). The establishment was informed by mail; system inspection and resampling were recommended. The water reticulation system was inspected and several valves replaced. The new sample was taken 22 days after the report was received. The TPC was now 150 (within tolerance). The results were reported within 48 hours.

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U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS	REVIE	WDATE	ESTABLISHMENT NO. AND NAME	•		CITY Padborg	
FOREIGN PLANT REVIEW FORM	2/1	/2002	179 - Agri-Norco	old	COUNTRY Denma		
NAME OF REVIEWER Dr. Gary D. Bolstad			IGN OFFICIAL besen, O.Nommensen, T. Sørens	EVALUATION Acceptable Re-re	ptable/ view Unaccep	otable	
CODES (Give an appropriate code for each A = Acceptable M = Margin			l below) U = Unacceptable	N =	Not Reviewed	O = Does not app	oly
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Chlorination procedures	02 O	Produc	t reconditioning	31 O	Label approvals		58 O
Back siphonage prevention	03 A	Produc	t transportation	32 A	Special label clain	ns	59 O
Hand washing facilities	04 A	(d) E	STABLISHMENT SANITATION PROGRAI		Inspector monitor	ing	60 A
Sanitizers	05 O	Effecti	ve maintenance program	33 A	Processing sched	ules	61 O
Establishments separation	06 A	Preope	rational sanitation	34 A	Processing equipr		62 O
Pestno evidence	07 A	Operat	ional sanitation	35 A	Processing record	ls	63 O
Pest control program	08 A	Waste	Waste disposal 36 Empty can inspec			ction	64 O
Pest control monitoring	09 A		2. DISEASE CONTROL		Filling procedures		65 O
Temperature control	10 A	Anima	Animal identification 370 Container closu		Container closure	exam	66 O
Lighting	11 A	Antem	Antemortem inspec. procedures 38 Interim co		Interim container	handling	67 O
Operations work space	12 A	Antem	Antemortem dispositions 39 Post-pr		Post-processing I	nandling	68 O
Inspector work space	13 O	Humar	ne Slaughter	40 O	Incubation proce	dures	69 O
Ventilation	14 A	Postm	ortem inspec. procedures	41 O	Process. defect a	actions plant	70 O
Facilities approval	15 A	Postm	ortem dispositions	42 O	Processing contr	ol inspection	71 O
Equipment approval	16 A	Conde	mned product control	43 O	5. COMPLIANCE/E	CON. FRAUD CONTRO)L
(b) CONDITION OF FACILITIES EQUIPME	NT	Restric	cted product control	44 O	Export product is	dentification	72 A
Over-product ceilings	17 A	Returr	ned and rework product	45 O	Inspector verifica	ation	73 A
Over-product equipment	18 A		3. RESIDUE CONTROL		Export certificate	es	74 A
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Other product areas (inside)	20 A	Samp	ling procedures	47 A	Inspection super	vision	⁷⁶ M
Dry storage areas	21 O	Resid	ue reporting procedures	48 A	Control of secur	ity items	77 A
Antemortem facilities	22 O		val of chemicals, etc.	49 A	Shipment securi	ty	78 A
Welfare facilities	23 A	Stora	ge and use of chemicals	50 A	Species verificat	tion	79 A
Outside premises	24 A		4. PROCESSED PRODUCT CONTROL	L	"Equal to" statu	S	80 A
(c) PRODUCT PROTECTION & HANDLE	NG	Pre-b	oning trim	51 O	Imports		81 A
Personal dress and habits	25 A	Bonel	ess meat reinspection	52 O	SSOPs		82 A
Personal hygiene practices	26 A	Ingre	dients identification	53 O	НАССР		83 O
Sanitary dressing procedures	27 O		ol of restricted ingredients	54 O			

				F-5b
	REVIEW DATE	ESTABLISHMENT NO. AND NAME		CITY Padborg
FOREIGN PLANT REVIEW FORM (reverse)	2/1/2002	179 - Agri-Norcold		COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FORE Drs. J.M. Ebb	eign Official Desen, O.Nommensen, T. Sørensen		ceptable/ Unacceptable

⁷⁶ There were no internal reviews during the months of June, July, or October 2001.

F-6a U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS REVIEW DATE | ESTABLISHMENT NO. AND NAME CITY Aabenraa 2/4/2002 190 - Aabenraa Frysehus COUNTRY FOREIGN PLANT REVIEW FORM Denmark NAME OF REVIEWER NAME OF FOREIGN OFFICIAL **EVALUATION** Acceptable/ Drs. H. Pedersen, O. Nimmensen; U. Mikkelsen Dr. Gary D. Bolstad X Unacceptable Acceptable CODES (Give an appropriate code for each review item listed below) Not Reviewed M = Marginally Acceptable U = Unacceptable N O = Does not apply A = Acceptable 55 28 **Formulations** Cross contamination prevention 1. CONTAMINATION CONTROL 0 29 56 (a) BASIC ESTABLISHMENT FACILITIES **Equipment Sanitizing** Packaging materials 0 A 30 U 57 O Product handling and storage Laboratory confirmation Water potability records 31 58 O ⁰²O Chlorination procedures Product reconditioning Label approvals 59 O 03 A Special label claims Product transportation Back siphonage prevention 04 **A** 60 A (d) ESTABLISHMENT SANITATION PROGRAM Inspector monitoring Hand washing facilities 61_O 05 A 33 M Processing schedules Sanitizers Effective maintenance program 62 A 34 U 06 A Processing equipment Preoperational sanitation Establishments separation 35 N 63 O 07 **A** Processing records Pest -- no evidence Operational sanitation 36 A 64_O Waste disposal Empty can inspection Pest control program 65 O 09 **A** Filling procedures Pest control monitoring 2. DISEASE CONTROL 10 A 37 O 66 O Animal identification Container closure exam Temperature control 11 A 38 Os 67 O Lighting Antemortem inspec. procedures Interim container handling 39 O 68 A 12 A Post-processing handling Antemortem dispositions Operations work space 40 O 69 O 13 O Incubation procedures Humane Slaughter Inspector work space 41_O 14 A Process. defect actions -- plant Ventilation Postmortem inspec. procedures 15 A ⁴²O 71 O Postmortem dispositions Processing control -- inspection Facilities approval 43 O Condemned product control 5. COMPLIANCE/ECON. FRAUD CONTROL Equipment approval 440 (b) CONDITION OF FACILITIES EQUIPMENT Restricted product control **Export product identification** 73 A 45 N Returned and rework product Inspector verification 17 **M** Over-product ceilings **Export certificates** Over-product equipment 3. RESIDUE CONTROL 19 [] 46 O Product contact equipment Residue program compliance Single standard 47 O 20 A ⁷⁶M Other product areas (inside) Sampling procedures Inspection supervision 48 O 21 M Control of security items Residue reporting procedures Dry storage areas 49 A Antemortem facilities Shipment security Approval of chemicals, etc. 23 A Welfare facilities Storage and use of chemicals Species verification 24 A "Equal to" status Outside premises 4. PROCESSED PRODUCT CONTROL Pre-boning trim Imports (c) PRODUCT PROTECTION & HANDLING 82 Personal dress and habits Boneless meat reinspection **SSOPs** M 53 O Personal hygiene practices Ingredients identification HACCP/PR Control of restricted ingredients Sanitary dressing procedures

				F-66
FOREIGN PLANT REVIEW FORM (reverse)	REVIEW DATE	ESTABLISHMENT NO. AND NAME		CITY
	2/4/2002	190 - Aabenraa Frysehus		Aabenraa
	27 17 2002	190 - Natomaa Hysem	15	COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FORE Drs. H. Peder	IGN OFFICIAL sen, O. Nimmensen; U. Mikkelsen		ceptable/

17/21/33 There were obvious holes in roughly a quarter of the ceiling tiles in the dry storage room. The management offical expressed willing- ness to program repairs.

18/33 Maintenance and cleaning of some over-product equipment had been neglected (this was a repeat finding), hand- operated rail gate switches had not been adequately cleaned, and there were old meat scraps from previous days' production and buildups of dust on the machine used to seal the product into foil pouches. DVFA officials ordered prompt corrections. Heavy rust buildups were found on the drive wheels and under the main product contact platform on a band saw that was used for product for human consumption. The management representative stated that the saw was used only once a week and would be cleaned before use, in addition to its having been cleaned after its last use.

19/34/82 Product-contact equipment (cutting boards, the main exposed-product conveyor belt, and edible product containers) had not been adequately cleaned before the start of operations. DVFA officials ordered re-cleaning of the equipment. The establishment personnel did so, and informed DVFA that it had been completed. The DVFA officials found that the re-cleaning had also been inadequate. Several items of product-contact equipment, that had been specifically identified with product residues from previous days' production, and pointed out to the establishment management had not been re-cleaned at all. DVFA ordered a complete re-cleaning of the entire area and daily monitoring by DVFA of the pre-operational sanitation before production would be allowed to begin, until further notice. Documentation by the Veterinarian-In- Charge indicated that the establishment's pre-operational sanitation inspections were inadequate approximately every second time he conducted his (bi-weekly) independent pre-operational sanitation checks.

30 Obvious contamination of product with ingesta was found in the cooler on product that had, according to establishment documen-

- 30 Obvious contamination of product with ingesta was found in the cooler on product that had, according to establishment documentation, passed inspection by the responsible management official. DVFA ordered complete inspection of all product in the cooler before it would be allowed to be used. Grossly excessive, falling snow was present in one of the two freezers entered during the audit. Many cartons of product were thickly covered with snow. No corrective actions were taken.
- 33/50 Cleaning compounds were stored on a very rusty metal shelf in a storage room that opened directly into the main boning room. No corrective actions were taken.
- 76 There were no internal reviews during the months of June, July, or October 2001.
- 82 Documentation of corrective actions was, at times, inadequate; preventive measures were not included in the corrective action documentation. Documentation by the Veterinarian-In-Charge indicated that the establishment's pre-operational sanitation inspections were inadequate approximately every second time he conducted his (bi-weekly) independent pre-operational sanitation checks. DVFA officials gave assurances they would enforce corrective action.
- 83a The establishment management was not documenting the monitoring of the CCP for absence of visible contamination of product at receiving. (Obvious contamination with ingesta was observed on a beef quarter in the cooler, that had, according to the documentation, been inspected by the responsible establishment official and passed.) DVFA ordered immediate correction.
- 83b The establishment had not developed verification procedures to ensure that the HACCP plan was working as intended to prevent product contamination (see item 30). This was a repeat finding. DVFA ordered prompt correction.
- 83c The establishment official performing the pre-shipment document review was the same person who monitored the critical limits.
- 80 The DVFA officials present during the audit determined that the establishment did not meet U.S. requirements and removed it from the list of establishments eligible for U.S. export, as of the start of operations on the day of the audit. The FSIS auditor was in complete agreement with this decision.

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U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE	REVIE	W DATE	ESTABLISHMENT NO. AND NAM	ME		CITY	
INTERNATIONAL PROGRAMS FOREIGN PLANT REVIEW FORM	2/13	3/2002	191 - Claus Sørensen	A/S, S	kagen	Skagen COUNTRY	
	NAME	OF FORE	IGN OFFICIAL	· · · · · · · · · · · · · · · · · · ·	EVALUATION	Denmark	
NAME OF REVIEWER Dr. Gary D. Bolstad			sen & I.Lahmann; Mr.T.R.Sør	ensen		ceptable/ -review Unacce	ptable
CODES (Give an appropriate code for each A = Acceptable M = Margir			l below) U = Unacceptable	N =	Not Reviewed	O = Does not ap	ply
1. CONTAMINATION CONTROL		Cross c	ontamination prevention	28 O	Formulations		55 O
(a) BASIC ESTABLISHMENT FACILITIES		Equipm	ent Sanitizing	29 O	Packaging mater	ials	56 A
Water potability records	01 A	Produc	t handling and storage	30 A	Laboratory confi	rmation	57 O
Chlorination procedures	02 O	Produc	t reconditioning	31 O	Label approvals		58 O
Back siphonage prevention	03 A	Produc	t transportation	32 A	Special label cla	ims	59 O
Hand washing facilities	04 A	(d) E	STABLISHMENT SANITATION PROGR	RAM	Inspector monito	oring	60 O
Sanitizers	05 A	Effecti	ve maintenance program	33 A	Processing sche	dules	610
Establishments separation	06 A	Preope	rational sanitation	34 A	Processing equip	pment	62 O
Pestno evidence	07 A	Operat	ional sanitation	35 A	Processing reco	rds	63 O
Pest control program	08 A	Waste	disposal	36 A	Empty can inspe	ection	64 O
Pest control monitoring	09 A		2. DISEASE CONTROL		Filling procedure	es	65 O
Temperature control	10 A	Anima	l identification	37 O	Container closu	re exam	66 O
Lighting	11 _A	Antem	ortem inspec. procedures	38 O	Interim containe	er handling	67 O
Operations work space	12 A	Antem	ortem dispositions	39 O	Post-processing	handling	68 O
Inspector work space	13 O	Humai	ne Slaughter	40 O	Incubation proc	edures	69 O
Ventilation	14 A	Postm	ortem inspec. procedures	41 O	Process. defect	actions plant	70 O
Facilities approval	15 A	Postm	ortem dispositions	42 O	Processing con	trol inspection	71 ₀
Equipment approval	16 A	Conde	emned product control	43 O	5. COMPLIANCE	JECON. FRAUD CONTR	OL
(b) CONDITION OF FACILITIES EQUIPME	NT	Restri	cted product control	44 O	Export product	identification	72 A
Over-product ceilings	17 A	Return	ned and rework product	45 O	Inspector verifi	cation	73 A
Over-product equipment	18 A		3. RESIDUE CONTROL		Export certifica	tes	74 A
Product contact equipment	19 O	Resid	ue program compliance	46 O	Single standard	i	75 A
Other product areas (inside)	20 O		ling procedures	47 O	Inspection supe	ervision	76 M
Dry storage areas	21 A	Resid	ue reporting procedures	48 O	Control of secu	urity items	77 A
Antemortem facilities	22 O	Appro	oval of chemicals, etc.	49 A	Shipment secu	rity	78 A
Welfare facilities	23 A		ge and use of chemicals	50 A	Species verific	ation	79 O
Outside premises	24 A	1	4. PROCESSED PRODUCT CONTRO		"Equal to" stat	tus	80 A
(c) PRODUCT PROTECTION & HANDLE	NG	Pre-b	oning trim	51 O	Imports		B1 A
Personal dress and habits	25 A	Bone	less meat reinspection	52 O			82 A
Personal hygiene practices	26 A		dients identification	53 O	LIA CCD/DD		83 O
Sanitary dressing procedures	27	Cont	rol of restricted ingredients	54 C)		
FSIS FORM 9520-2 (2/93) REPLACES			/90), WHICH MAY BE USED UNTIL EXHAUS	STED.	Designed on Per	FORM PRO Software by D	elrina

				F-7b
FOREIGN PLANT REVIEW FORM	REVIEW DATE ESTABLISHMENT NO. AND NAME			CITY
	2/13/2002 191 - Claus Sørensen A/S, Sl		Skagen	Skagen
(reverse)	271372002	171 - Claus Swichsch A/S,	Skagen	COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs.J.M.Ebbesen & I.Lahmann; Mr.T.R.Sørensen		ceptable/
	<u> </u>	,	Acceptable Re-	review Unacceptable

⁷⁶ There had been no supervisory internal reveiw in May 2001, reportedly due to a misunderstanding between the two regional reviewers.

T.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS	HEVIE	WDAIE	ESTABLISHMENT NO. AND NAME	CITY Ebeltoft			
FOREIGN PLANT REVIEW FORM	2/1	9/2002	205 - Steff Houlberg E	g Ebeltoft A.M.B.A.		COUNTRY Denmark	
NAME OF REVIEWER Dr. Gary D. Bolstad	Drs.	ME OF FOREIGN OFFICIAL S. Henning Petersen, Knud Fallesen, R. Hansen Acceptable Acceptable Acceptable Acceptable					ptable
CODES (Give an appropriate code for each A = Acceptable M = Margin			below) U = Unacceptable	N =	Not Reviewed	O = Does not ap	ply
1. CONTAMINATION CONTROL		Cross c	ontamination prevention	28 A	Formulations		55 A
(a) BASIC ESTABLISHMENT FACILITIES		Equipment Sanitizing 2		29 A	Packaging mater	ials	56 A
Water potability records	01 A	Product	handling and storage	30 A	Laboratory confi	rmation	57 A
Chlorination procedures	02 A	Produc	t reconditioning	31 A	Label approvals		58 O
Back siphonage prevention	03 A	Produc	t transportation	32 O	Special label clai	ms	59 O
Hand washing facilities	04 A	(d) E	STABLISHMENT SANITATION PROGRAI	М	Inspector monito	oring	60 A
Sanitizers	05 A	Effectiv	ve maintenance program	33 M	Processing sche	dules	61 A
Establishments separation	06 A	Preope	rational sanitation	34 A	Processing equip	ment	62 A
Pestno evidence	07 A	Operat	ional sanitation	35 A	Processing records		63 A
Pest control program	08 A	Waste	disposal	36 A	Empty can inspection		64 O
Pest control monitoring	09 A		2. DISEASE CONTROL		Filling procedures		65 O
Temperature control	10 A	Animal	nimal identification 37 Container closure		e exam	66 O	
Lighting	11 A			Interim containe	r handling	67 A	
Operations work space	12 A	Antem	ortem dispositions	39 O	Post-processing handling		68 A
Inspector work space	13 O	Humar	e Slaughter	⁴⁰ O Incubation procedures		edures	69 O
Ventilation	14 A	Postm	ortem inspec. procedures	41 O	Process. defect	actions plant	70 A
Facilities approval	15 A	Postm	ortem dispositions	42 O	Processing cont	rol inspection	71 A
Equipment approval	16 A	Conde	mned product control	43 A	5. COMPLIANCE	ECON. FRAUD CONTRO	DL
(b) CONDITION OF FACILITIES EQUIPMENT	NT	Restric	ted product control	44 A	Export product	identification	72 A
Over-product ceilings	17 A	Return	ed and rework product	45 A	Inspector verific	ation	73 A
Over-product equipment	18 M		3. RESIDUE CONTROL		Export certificat	es	74 A
Product contact equipment	19 M	Residu	e program compliance	46 O	Single standard		75 A
Other product areas (inside)	20 A	Sampl	ing procedures	47 O	Inspection supe	rvision	76 A
Dry storage areas	21 A	Residu	e reporting procedures	48 O	Control of secu	rity items	77 A
Antemortem facilities	22 O	Appro	val of chemicals, etc.	49 A	Shipment secur	ity	78 A
Welfare facilities	23 A	Storag	ge and use of chemicals	50 A	Species verifica	ition	79 M
Outside premises	24 A		4. PROCESSED PRODUCT CONTROL	<u> </u>	"Equal to" state	ıs	80 A
(c) PRODUCT PROTECTION & HANDLIN	IG	Pre-bo	ning trim	51 A	Imports		81 A
Personal dress and habits	25 A	Bonel	ess meat reinspection	52 A	SSOPs		82 A
Personal hygiene practices	26 A	Ingred	lients identification	53 A	HACCP/PR		83 M
Sanitary dressing procedures	27 O	Contr	ol of restricted ingredients	54 O			1

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FOREIGN PLANT REVIEW FORM		ESTABLISHMENT NO. AND NAME 205 - Steff Houlberg Ebeltoft A.M.B.A.		CITY Ebeltoft
(reverse)	2/19/2002	203 - Steff Houlberg Ebelto	If Houlberg Ebeltoff A.M.B.A.	
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FORE Drs. Henning	Petersen, Knud Fallesen, R. Hansen		cceptable/ -raview Unacceptable

- 18/33 Maintenance and cleaning of over-product structures (rail gate switch handles and rail structures) had been negleted in one cooler for hams and shoulders. The gate switches were cleaned immediately, and the management representative scheduled prompt correction for the other structures.
- 19 Large plastic containers for edible product were routinely placed directly on the floor, and a number of these containers, that had not been adequately cleaned, were stacked and ready for use. The DVFA officials ordered corrective actions and agreed to ensure continued resolution of the problem. Also, several cracked stainless steel combo bins were in use. The management official ordered them taken out of production for repair.
- 79 No species verification was performed on product from this establishment, although both pork and beef were processed. The DVFA officials gave assurances this would be corrected promptly.
- 83a Pre-Shipment Document Reviews were not implemented until January 11, 2002. No product was exported directly to the U.S. from this establishment, but products were routinely sent to a sister establishment for U.S.-eligible further production. Note: prior to the implementation of PSDRs, monitoring of critical limits had been reliably performed and documented.
- 83b HACCP plans had individual CCPs with multiple critical limits. The management agreed to correct this promptly.

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS	REVIE	W DATE	ESTABLISHMENT NO. AND NAM	E		CITY Aabybro	
FOREIGN PLANT REVIEW FORM	12/	2/2002	2/2002 286 - EdiDan (Edible Danish Proteins)		h Proteins)		
NAME OF REVIEWER Dr. Gary D. Bolstad			IGN OFFICIAL bbesen, I. Lahmann, L. Mogsta	ad	EVALUATION Acceptable Re	cceptable/ Unacce	entable
CODES (Give an appropriate code for each A = Acceptable M = Margi	review	item listed		N =	Not Reviewed	O = Does not ap	
1. CONTAMINATION CONTROL		Cross c	ontamination prevention	28 A	Formulations		55 A
(a) BASIC ESTABLISHMENT FACILITIES		Equipm	ent Sanitizing	29 A	Packaging mater	rials	56 A
Water potability records	01 A	Produc	t handling and storage	30 A	Laboratory confirmation		
Chlorination procedures	02 O	Produc	t reconditioning	31 O	Label approvals		58 O
Back siphonage prevention	03 A	Produc	t transportation	32 O	Special label cla	ims	59 O
Hand washing facilities	04 A	(d) E	STABLISHMENT SANITATION PROGRA		Inspector monito	oring	60 A
Sanitizers	05 O	Effecti	ve maintenance program	33 A	Processing sche	dules	61 O
Establishments separation	06 A	Preope	rational sanitation	34 A	Processing equip	pment	62 A
Pestno evidence	07 A	Operat	ional sanitation	35 A	Processing reco	rds	63 A
Pest control program	08 A	Waste	disposal	36 A	Empty can inspe	ection	64 O
Pest control monitoring	09 A		2. DISEASE CONTROL	. 1	Filling procedures		65 A
Temperature control	10 A	Anima	identification	dentification 37 Container closure e			66 O
Lighting	11 A	Antem	ortem inspec. procedures	38 O	Interim containe	er handling	67 O
Operations work space	12 A	Antem	emortem dispositions 39 Post-processing		handling	68 A	
Inspector work space	13 O			Incubation proc	edures	69 O	
Ventilation	14 A	Postm	ortem inspec. procedures	41 _O	Process. defect	actions plant	70 A
Facilities approval	15 A	Postm	ortem dispositions	42 O	Processing conf	trol inspection	71 A
Equipment approval	16 A	Conde	mned product control	43 A	5. COMPLIANCE	/ECON. FRAUD CONTR	OL
(b) CONDITION OF FACILITIES EQUIPM	ENT	Restric	cted product control	44 O	Export product	identification	72 A
Over-product ceilings	17 A	Return	ed and rework product	45 O	Inspector verific	cation	73 A
Over-product equipment	18 A		3. RESIDUE CONTROL		Export certifica	tes	74 A
Product contact equipment	19 A	Residu	ue program compliance	46 O	Single standard		75 A
Other product areas (inside)	20 A	Samp	ing procedures	47 O	Inspection supe	ervision	76 A
Dry storage areas	21 A	Residu	ue reporting procedures	48 O	Control of secu	rity items	77 A
Antemortem facilities	22 O	Appro	val of chemicals, etc.	49 A	Shipment secu	rity	78 A
Welfare facilities	23 A		ge and use of chemicals	50 A	Species verifica	ation	79 O
Outside premises	24 A		4. PROCESSED PRODUCT CONTROL	. 1	"Equal to" stat	us	80 A
(c) PRODUCT PROTECTION & HANDL	ING	Pre-bo	oning trim	51 O	Imports		81 A
Personal dress and habits	25 A	Bonel	ess meat reinspection	52 O			82 A
Personal hygiene practices	26 A		dients identification	53 A	UA CCD/DD		83 A
Sanitary dressing procedures	27	Contr	ol of restricted ingredients	54 O			··
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FOREIGN PLANT REVIEW FORM		ESTABLISHMENT NO. AND NAME		CITY Aabybro
(reverse)	12/2/2002	286 - EdiDan (Edible Danis	sh Proteins)	COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FORE Drs. J.M. E	EIGN OFFICIAL Ebbesen, I. Lahmann, L. Mogstad		ceptable/ review Unacceptable

COMMENTS:

No comments.

F-10a

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS	ŀ	W DATE		_		CITY Skaerbaek	
FOREIGN PLANT REVIEW FORM	2/5	5/2002 311 - Danish Crown Skaerbaek		COUNTRY Denmark			
NAME OF REVIEWER Dr. Gary D. Bolstad	Drs.	H. Peder	IGN OFFICIAL sen, O. Nimmensen, J. Christer	nsen		ceptable/ review Unecce	ptable
CODES (Give an appropriate code for each $A = Acceptable$ $M = Margin$			below) U = Unacceptable	N =	Not Reviewed	O = Does not ap	pły
1. CONTAMINATION CONTROL		Cross c	ontamination prevention	28 A	Formulations		55 O
(a) BASIC ESTABLISHMENT FACILITIES		Equipm	ent Sanitizing	29 A	Packaging mater	ials	56 A
Water potability records	01 A	Product	handling and storage	30 M	Laboratory confi	rmation	57 A
Chlorination procedures	02 O	Produc	reconditioning	31 A	Label approvals		58 O
Back siphonage prevention	03 A	Produc	t transportation	32 A	Special label clai	ms	59 O
Hand washing facilities	04 A	(d) E	STABLISHMENT SANITATION PROGRA		Inspector monito	oring	60 A
Sanitizers	05 A	Effectiv	ve maintenance program	33 A	Processing sche	dules	61 O
Establishments separation	06 A	Preope	rational sanitation	34 M	Processing equip	oment	62 O
Pestno evidence	07 A	Operat	ional sanitation	35 A	Processing recor	ds	63 O
Pest control program	08 A	Waste	disposal	36 A	Empty can inspe	ection	64 O
Pest control monitoring	09 A		2. DISEASE CONTROL		Filling procedure	s	65 O
Temperature control	10 A	Animal	identification	37 A	Container closur	e exam	66 O
Lighting	11 M	Antem	ortem inspec. procedures	38 A	Interim containe	r handling	67 O
Operations work space	12 A	Antemortem dispositions 39 Post-processing		Post-processing	handling	68 O	
Inspector work space	13 A	Humar	e Slaughter	40 A	Incubation proce	edures	69 O
Ventilation	14 A	Postm	ortem inspec. procedures	41 A	Process. defect	actions plant	70 O
Facilities approval	15 A	Postm	ortem dispositions	42 A	Processing cont	rol inspection	71 ₀
Equipment approval	16 A	Conde	mned product control	43 A	5. COMPLIANCE	ECON. FRAUD CONTRO	OL
(b) CONDITION OF FACILITIES EQUIPME	NT	Restric	ted product control	44 A	Export product	identification	72 A
Over-product ceilings	17 A	Return	ed and rework product	45 A	Inspector verific	ation	73 A
Over-product equipment	18 M		3. RESIDUE CONTROL		Export certificat	tes	74 A
Product contact equipment	19 M		e program compliance	46 A	Single standard		75 A
Other product areas (inside)	20 A	Sampl	ing procedures	47 A	Inspection supe	rvision	76 A
Dry storage areas	21 A	Residu	e reporting procedures	48 A	Control of secu	rity items	77 A
Antemortem facilities	22 A	Appro	val of chemicals, etc.	49 A	Shipment secur	ity	78 A
Welfare facilities	23 A	Storag	ge and use of chemicals	50 M	Species verifica	ition	79 A
Outside premises	24 A		4. PROCESSED PRODUCT CONTROL	_1	"Equal to" stati	JS	80 A
(c) PRODUCT PROTECTION & HANDLIN	₩G	Pre-bo	oning trim	51 A	Imports		81 A
Personal dress and habits	25 A	Bonel	ess meat reinspection	52 O	SSOPs		82 A
Personal hygiene practices	26 A	-	lients identification	53 O			83 A
Sanitary dressing procedures	27 A	Contr	ol of restricted ingredients	54 O			
FSIS FORM 9520-2 (2/93) REPLACES F	SIS FORM	9520-2 (11/	90), WHICH MAY BE USED UNTIL EXHAUSTE	D.	Designed on Perf	ORM PRO Software by De	lrina

				F-10b
	REVIEW DATE	ESTABLISHMENT NO. AND NAME		CITY
FOREIGN PLANT REVIEW FORM (reverse)	2/5/2002	311 - Danish Crown Skaerbaek		Skaerbaek
	2/3/2002	311 - Dainsh Clown Ska	CIVACK	COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FORE	Sen O Nimmensen I Christensen	EVALUATION	centable/

11 Light was inadequate at two postmortem inspection areas: an intensity of 10 foot-candles (fc) was measured at the surfaces of mandibular lymph nodes and 30 fc in abdominal cavities at the retained rail. DVFA officials ordered prompt correction.

18/30 Condensation was observed in several areas of carcass coolers, directly above exposed product, before the start of cutting operations. DVFA ordered corrective actions immediately. Several trees of pork shoulders that had been stored under the worst problem area were ordered to be identified for cooking only.

19/34 Numerous items of product-contact equipment, including cutting boards, hoist switches, and line control switches, had not been adequately cleaned before the start of operations. DVFA officials identified most of the overlooked items; the FSIS Auditor identified several others. All were ordered to be thoroughly cleaned before work was allowed to start, reinspected, and passed. All identified items were re-cleaned properly except one hoist switch, one hand saw, and one electricity control. These were corrected immediately when brought to the establishment's content.

50 Some chemicals (including hand soap) were stored under insanitary conditions. DVFA officials ordered prompt correction.

INTERNATIONAL PROGRAMS FOREIGN PLANT REVIEW FORM	2/1:	5/2002					
		312002	469 - Danish Crown H	ladsun	d	COUNTRY Denmark	
NAME OF REVIEWER Dr. Gary D. Bolstad	Drs.	J.M.Ebb	ign official esen, I.Lahrmann, R.S. P ete rsen		EVALUATION Acceptable Acc	ceptable/ review Unaccap	otable
CODES (Give an appropriate code for each r A = Acceptable M = Margina			l below) U = Unacceptable	N =	Not Reviewed	O = Does not app	oly
1. CONTAMINATION CONTROL		Cross c	ontamination prevention	28 A	Formulations		55 A
(a) BASIC ESTABLISHMENT FACILITIES		Equipm	ent Sanitizing	29 A	Packaging materi	als	56 A
Water potability records	01 A	Product	t handling and storage	30 A	Laboratory confir	mation	57 A
Chlorination procedures	02 O	Produc	t reconditioning	31 A	Label approvals		58 A
Back siphonage prevention	03 A	Produc	t transportation	32 O	Special label clai		59 O
Hand washing facilities	04 A	(d) E	STABLISHMENT SANITATION PROGRAI	ч	Inspector monito		60 A
Sanitizers	05 A	Effectiv	ve maintenance program	33 M	Processing sched	dules	61 A
Establishments separation	06 A	Preope	rational sanitation	34 A	Processing equip	ment	62 A
Pestno evidence	07 A	Operat	ional sanitation	35 A	Processing recor		63 A
Pest control program	08 A	Waste	disposal	36 A	Empty can inspe		64 O
Pest control monitoring	09 A		2. DISEASE CONTROL		Filling procedure	S	65 O
Temperature control	10 A	Animal	identification	37 O	Container closur	e exam	66 O
Lighting	11 A	Antem	ortem inspec. procedures	38 O	Interim containe	r handling	67 O
Operations work space	12 A	Antemortem dispositions 39 Post-processing		Post-processing	handling	68 A	
Inspector work space	13 A	Humar	ne Slaughter	40 O	Incubation proce	edure s	69 O
Ventilation	14 A	Postm	ortem inspec. procedures	41 O	Process. defect	actions plant	70 A
Facilities approval	15 A	Postm	ortem dispositions	42 O	Processing cont	rol inspection	71 A
Equipment approval	16 A	Conde	mned product control	43 A	5. COMPLIANCE/	ECON. FRAUD CONTRO)L
(b) CONDITION OF FACILITIES EQUIPMEN	iT	Restric	cted product control	44 O	Export product i	dentification	72 A
Over-product ceilings	17 A	Return	ned and rework product	45 A	Inspector verific	ation	73 A
Over-product equipment	18 M		3. RESIDUE CONTROL		Export certificat	es	74 A
Product contact equipment	19 A	Residu	ue program compliance	46 O	Single standard		75 A
Other product areas (inside)	20 A	Sampl	ing procedures	47 O	Inspection supe	rvision	76 M
Dry storage areas	21 A	Residu	ue reporting procedures	48 O	Control of secu	rity items	77 A
Antemortem facilities	22 O	Appro	val of chemicals, etc.	49 A	Shipment secur	ity	78 A
Welfare facilities	23 A	Storag	ge and use of chemicals	50 A	Species verifica	tion	79 O
Outside premises	24 A		4. PROCESSED PRODUCT CONTROL		"Equal to" state	ıs	80 A
(c) PRODUCT PROTECTION & HANDLIN		Pre-bo	oning trim	51 A	Imports		81 A
Personal dress and habits	25 A	Bonel	ess meat reinspection	52 A	SSOPs		82 A
Personal hygiene practices	26 A	Ingred	dients identification	53 A	HACCP/PR		83 A
Sanitary dressing procedures	27 O		ol of restricted ingredients	54 O			1.5

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FOREIGN PLANT REVIEW FORM (reverse)	2/15/2002	ESTABLISHMENT NO. AND NAME 469 - Danish Crown Hadsu	nd	CITY Hadsund COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FORE Drs. J.M.Ebb	IGN OFFICIAL esen, I.Lahrmann, R.S. Petersen		ceptable/ review Unacceptable

18/33 Maintenance and cleaning of some over-product equipment had been neglected in numerous areas throughout the establishment. The establishment management official gave assurances that they all would receive prompt attention.

76 There were no internal reviews for the months of July, August, or September 2001, although there was supporting documentation that the supervisory reviewer had paid several visits to the establishment during each of those months.